

Work Order ID 79741

June-19-12 11:23:44 AM

Duplicate

79741

Page 1

Item ID: D6019-128 Accept *N900040100* Setup Start *NS1*
 Revision ID: Stop *NS2*
 Item Name: Crosstube Material
 Start Date: 2/01/12 Start Qty: 10.00 *10* Cust Item ID:
 Required Date: 3/16/12 Req'd Qty: 10.00 *10* Customer:
 Reference:

Approvals: Process Plan: *[Signature]* Date: Tooling: Date: Run Start *NR1*
 QC: Date: SPC (Y/N): Date: Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr	Revision Nbr
D6019	Rev A

100 PURCHASING 0.00
 100
 Purchasing Memo 16003 0.00
 Purchasing Issue P/O: *16003* a) Order as per Dwg D6019 b) Material: 2.750
 x 0.313 wall 7075-T6/T6511 (WW-T-700/7 or QQ-A-225/9 or QQ-A-200/11)
 seamless aluminum tube c) Minimum ultimate tensile strength = 77 ksi d)
 Minimum tensile yield strength = 66 ks

u 12-01-02

110 Receive & Inspect for Damage & Mat'l Certs 0.00
 110
 Packaging Memo 0.00
 Packaging Ensure material certification is attached

[Signature] 12/8/26 (10)

120 QC6- Inspect dimensions to drawing 0.00
 120
 QC Memo 0.00
 Quality Control Ensure Material certification comply to Dwg D6005

*As Per Dwg Ensure
 Schuero*

(A)

Work Order ID 79741

79741

Page 2

June-19-12 11:23:44 AM

Item ID: D6019-128 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Crosstube Material
 Start Date: 2/01/12 Start Qty: 10.00 ***10*** Cust Item ID:
 Required Date: 3/16/12 Req'd Qty: 10.00 ***10*** Customer:
 Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130 *130* HandFinish Hand Finishing	Chemical Conversion Coat per QSI005 4.1 Memo N/A 9/24/13	0.00 0.00							
140 *140* QC Quality Control	QC3- Inspect Part Finish Memo N/A 9/24/13	0.00 0.00							
150 *150* Packaging Packaging	Identify as per dwg & Stock Location: 46 Memo	0.00 0.00							

12-7-3
 7

See attached e-mail for QTY.
 8/12-7-3

Work Order ID 79741

79741

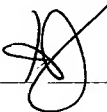
Page 3

June-19-12 11:23:44 AM

Item ID: D6019-128 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Crosstube Material
 Start Date: 2/01/12 Start Qty: 10.00 ***10*** Cust Item ID:
 Required Date: 3/16/12 Req'd Qty: 10.00 ***10*** Customer:
 Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
160	QC21- Final Inspection - Work Order Release	0.00							
160									
QC	Memo	0.00							
Quality Control									

12/7/4 

12-07-4

Picklist Print

June-19-12 11:23:03 AM

Page 1

Work Order ID: 79741

Parent Item: D6019-128

Start Date: 2/01/12

Required Date: 3/16/12

Parent Item Name: Crosstube Material

Start Qty: 10.00

Required Qty: 10.00

Comments: IPP Rev.A New Issue LL

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D6019-128P Crosstube Material		Purchased	No				Each	17.0000		10		6/25/12	

Location

Loc Qty

Loc Code

ST

17

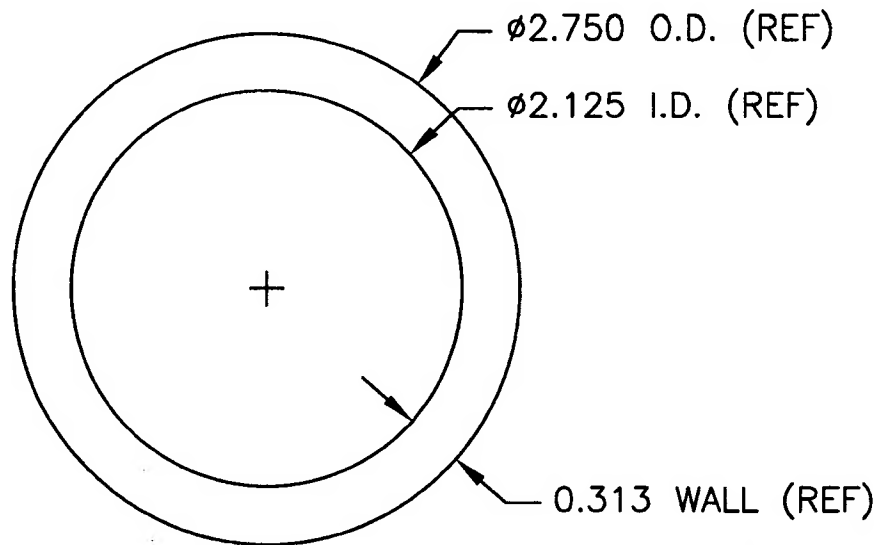
79741

17

DART

DESIGN <i>qp</i>	DRAWN BY <i>qp</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D6019	REV. A SHEET 1 OF 1
DATE 06.11.03		TITLE CROSSTUBE MATERIAL	SCALE 1:1
A	06.11.03	NEW ISSUE	

SPECIFICATION CONTROL DRAWING

RELEASED07.04.09 *[Signature]**mtb
06/11/03*

NOTES

- 1) D6019-XXX CROSSTUBE
LENGTH

WHERE XXX IS LENGTH IN INCHES
EG. 128" LONG TUBE: D6019-128

- 2) MATERIAL: 2.750 OD x 0.313 WALL 7075-T6/T6511 (WW-T-700/7 OR QQ-A-225/9 OR QQ-A-200/11) SEAMLESS ALUMINUM TUBE.
MINIMUM ULTIMATE TENSILE STRENGTH = 77 ksi
MINIMUM YIELD TENSILE STRENGTH = 66 ksi
- 3) TOLERANCES ARE PER ASTM B210 AS FOLLOWS:
O.D.: ± 0.006 MEAN (± 0.012 INCLUDING OVALITY)
WALL: ± 0.015 MEAN (± 0.038 INCLUDING ECCENTRICITY)
LENGTH: XXX $+0.125/-0.000$
STRAIGHTNESS: 0.010" DEVIATION / 12" LENGTH
- 4) EXTREME CARE MUST BE TAKEN TO PROTECT THE OUTSIDE SURFACE OF THE TUBE. THE OUTSIDE SURFACE MUST BE SMOOTH AND FREE FROM SURFACE DEFECTS SUCH AS SCRATCHES, NICKS, OR DENTS. DEFECTS UP TO 0.005" MAY BE BLENDED OUT LONGITUDINALLY. CIRCUMFERENTIAL GRIND MARKS ARE UNACCEPTABLE.
- 5) CHEMICAL CONVERSION COAT PER DART QSI 005 4.1

Copyright © 2006 by DART AEROSPACE LTD

THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.

Sent on: May 26, 2012 10:00:47 AM

All amounts are calculated in domestic currency.

Page 1 of 1

All Vendors PO ID PO#6666 Receipt Dates from 5/26/2012 to 5/26/2012 All Line Item Types
All Item ID#GLW/Os All Rec. Employees All Currents
Grouped by Vendor ID

[illegible]

06/19/2012 TUE 11:43 FAX 613 632 4443 DART HELICOPTER SERVICES

002/013

05/22/12

KAISER ALUMINUM FABRICATED PRODUCTS, LLC
PACKING LIST

PAGE 10

KAISER ALUMINUM - KALAMAZOO
5205 KAISER DRIVE
KALAMAZOO, MI 49002
DART AEROSPACE LTD
1270 ABERDEEN
STREET
HAWKESBURY ON K6A 1K7

SOLD TO
DART AEROSPACE LTD
HAWKESBURY ON K6A 1K7
INSIDE SALES REP
FACIO
BILL OF LADING
SHIP DATES
CARRIER
LOAD NUMBER
TOTAL GROSS WT

600502
05/22/12
JWS
B247
627 LBS.
SHIPMENT NBR- 614019 0001

SHIP ITEM RELEASE	ITEM DESCRIPTION	P.O. NUMBER	LOT NUMBER	PACKAGE NUMBER	PACK PIECES	GROSS WT	NET WT	BACK POSTAGE ORDER
1 614019	001 SPIRIT-372415 02.875 2.905#/FT **** 7075T5511 123.0000 IN +/-2500 -0 IN TOL 1075 T6513 2.750" OD X .313" WALL BA EST	COMPLETE 15053	*7072 003 Dash 0001	0000068191	5 5	180	155	53.33
2			7072 003 Dash 0001	0000068192	6 6	211	186	54.00
3			7072 003 Dash 0001	0000068193	3 3	118	93	32.00
4			7072 003 Dash 0001	0000068194	3 3	118	93	32.00
TOTAL:						17	627	181.33
TOTAL NET WT						527	POUNDS	181.33

27

2010/06/19

* MATERIAL CERTIFICATION REQUIRED FOR THIS LOT NUMBER.

KAISER ALUMINUM FABRICATED PRODUCTS

Best in Class

CERTIFIED TEST REPORT

<http://Online.KaiserAluminum.com>

KAISER ALUMINUM
FABRICATED PRODUCTS, LLC
5205 KAISER DRIVE
KALAMAZOO, MI 49048

CUSTOMER PO NUMBER: 16068-1		CUSTOMER PART NUMBER: SPIRIT-372415		PRODUCT DESCRIPTION: 7075 T6511 2.750 OD X .313 WALL HA EST	
KAISER ORDER NUMBER: 614019	LINE ITEM: 001	SHIP DATE: 05/22/2012	KAISER LOT NUMBER: 70072 003	ALLOY: 7075	TEMPER: T6511
WEIGHT SHIPPED: 527.000 LB	QUANTITY: 17.000 PCS	BL NUMBER: 603504	DIAM/DAF/THKNS: 	WIDTH: 	LENGTH: 10.666 FT
SHIP TO: DART AEROSPACE LTD 1270 ABERDEEN STREET HAWKESBURY, ON K6A 1K7 CANADA			SOLD TO: DART AEROSPACE LTD 1270 ABERDEEN STREET HAWKESBURY, ON K6A 1K7 CANADA		

Actual Physical Properties

REFERENCE	DASH#	SAMPLE#	UTS (KSI)	YTS (KSI)	ELONG%	HARDNESS	CONDUCT.
BEND							

Chemical Composition (wt%), Aluminum Remainder

LIMITS	Si	Fe	Cu	Mn	Mg	Cr	Zn	Ti	Pb	Bi	Zr	Ea	Tot
Maximum	0.10	0.50	2.00	0.30	2.90	0.28	6.10	0.20	NA	NA	NA	0.05	0.15
Minimum	0.00	0.00	1.20	0.00	2.10	0.18	5.10	0.00	NA	NA	NA	0.00	0.00
D33464	.08	.20	1.26	.03	2.71	.19	5.77	.02	.00	.00	.01	.01	.02

Applicable Requirements:

No Weld Repair. Mercury Free.

Miscellaneous Notes

MANUFACTURED IN USA MELTED IN USA

CERTIFICATION

Kaiser Aluminum Fabricated Products, LLC ("Kaiser") hereby certifies that metal shipped under this order has been inspected and tested and found in conformance with the applicable specifications forming a part of the description set forth in Kaiser's sales acknowledgement form. Any warranty is limited to that shown on Kaiser's general terms & conditions of sale. Test reports are on file subject to examination.

Alex Yeh, Quality & Technology Manager

Alex Yeh

Plant Serial: 00045052

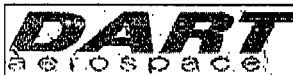
Kaiser Order Number: 614019

Line Item: 001

Page 1 of 1

003/013

06/19/2012 TUE 11:43 FAX 613 632 4443 DART HELICOPTER SERVICES



Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
Tel: 613 632 9577
Fax: 613 632 1053

PURCHASE ORDER

Purchase Order ID: PO16063

Purchase Order Date: 2/01/12

PO Print Date: 2/14/12

Page Number: 1 of 1

Order From:

KAISER ALUMINUM
6573 W WILLIS ROAD

CHANDLER, ARIZONA 85226
USA

VU:KAJ001

Contact Name

Vendor Phone: 520 796 1097 Ext.1020

Vendor Fax: 520 796 0596

Vendor Account Nbr

Buyer

Requisition Nbr

Trx Resale Nbr

Terms

Currency

FOB

Chantal Lavoie

10127-2607

Net 30

USD

Destination-Collect

Ship To:

DART AEROSPACE LTD

1270 ABERDEEN
HAWKESBURY, ON K6A 1K7
CANADA

RECEIVED

Line Nbr	Reference Revision ID Vendor Part Number	Description/ Mfg ID	Req Date/ Taxable	Req Qty/ Unit of Measure	Ship Method	Unit Price	Extended Price
1	D6019-128P	Cross-tube Material	3/16/12 Yes	17.00 Each		\$723.9400	\$12,310.98

Special Inq: AS PER DWO D6019 REV. A
B79741
MATERIAL: T6511 AS PER QQ-A-223/9
OR QQ-A-200/11
SIZE: 2.750" X 0.313" WALL SEAMLESS
ALUMINUM TUBE
MINIMUM ULTIMATE TENSILE
STRENGTH = 77 KSI
MINIMUM TENSILE YIELD STRENGTH
= 66 KSI

NOTE: PLEASE PRODUCE IN T6511

PO Total:

\$12,310.98

MATERIAL CERTIFICATION
REQ'D UPON DELIVERY

PO Instructions: quotation no. 525407

Change Nbr: 2

Change Date: 2/14/12

No substitution or deviation without
consent.
Certificate of Conformity or Material
Certification required when applicable.

004/013

06/19/2012 TUE 11:43 FAX 613 632 4443 DART HELICOPTER SERVICES

Chantal Lavoie

From: Linda Lacelle <llacelle@dartaero.com>
Sent: February 14, 2012 10:37 AM
To: 'Facio, Nathan M.'
Cc: 'Mahan, Steve'; clavoie@dartaero.com
Subject: RE: PO 16063; Kaiser Quote 525407

Good Morning,

We are all in agreement to proceed with the new quote, and your exceptions. Please produce in T6511. Please ensure all the information we gave to Nat, gets implemented into this PO.

Chantal will be sending the revised PO shortly.

Thank You,

Linda Lacelle

Production manager

Dart Aerospace

From: Facio, Nathan M. [<mailto:Nathan.Facio@kaiserai.com>]
Sent: February-13-12 6:55 PM
To: clavoie@dartaero.com
Cc: Mahan, Steve; llacelle@dartaero.com
Subject: PO 16063; Kaiser Quote 525407

Hi Chantal Lavoie,

I have attached a copy of our Quote 525407, in pdf format. Note the price per pound and advise which temper you will want us to mfg, so we can enter this PO in our system.

- 527 lbs (17 pieces) minimum, \$23.74/lb.
- Advise on temper: T6, or T6511.

One more thing, please note on our quote the exceptions we are taking to your print: D6019-128P.

Thank you,

Nathaniel M. Facio - Inside Sales Rep
Kaiser Aluminum - 6573 W. Willis Rd - Chandler AZ 85226.
P: 520-796-3220 Plant Fax: 520-796-0596.

CONFIDENTIAL COMMUNICATION

This email message and any attachments are intended only for the use of the addressee named above contain information that is privileged and confidential. If you are not the intended recipient, any dissemination, distribution, or copying is strictly prohibited. If you received this email message in error, please immediately notify the sender by replying to this email message or by telephone (520) 796-1097 EX 20 and then DELETE the message. Thank You.

KAISER ALUMINUM

QUOTATION

See additional notes at the end of this quote.

Quote Number: 826407

Date: 2/13/2012

Page: 1 of 2

Contact: CHANTAL LAVOIE

Phone:

Fax:

E-Mail: clavoie@dartaero.com

Sold To: DART AEROSPACE LTD
1270 ABERDEEN
STREET
HAWKESBURY, ON K6A 1K7
CANADA

Customer Ref:

Quote Reference:

Quote Expires: 2/13/2012

CC To: lavoie@dartaero.com Steve Mahan

Ship To: DART AEROSPACE LTD
1270 ABERDEEN
STREET
HAWKESBURY, ON K6A 1K7
CANADA

KAISER ALUMINUM is pleased to provide the following quotation based on today's metal prices, for shipment at one time to one destination. This quotation is not a contract. Price and schedule are not firm and are subject to reconfirmation at time of order placement. Orders resulting from this quote that are accepted and approved by Kaiser will be subject to Kaiser Aluminum's standard terms and conditions of sale.

TERMS: CASH BEFORE SHIPMENT

FOB: Destination

END USE:

NOTES: LENGTH TOLERANCE: $-0.000/+0.250$

Item	Alloy Temper	Dimensions	Length	Quantity	Unit Price	Leadtime
1	7075 T6	OD: 2.750" OD+: 0.008 ID: 2.125" Wall: 0.313" Wall+: 0.015 Wall-: 0.015	128.0000 In	527 LB	\$23,740/LB	13-14 wks ARO
Round (RA ESRT) (Tube RA Extruded Seamless)						

Kaiser Part No.: 372414

Weight/Ft: 2.9047600

Ship Tolerance: +15%/-15%

Specification: AMS-QQ-A-200/11

Non-Stenciled

Batten: All 4 sides

External: Cardboard box

Internal: Paper Layer Separation

Item Notes:

THIS IS THE MILL MINIMUM. D6019-128B WITH EXCEPTIONS. WE TAKE EXCEPTION TO OD TOLERANCE AND ARE ONLY OFFERING ± 0.008 MEAN READINGS; OFFERING OVALITY OF: ± 0.015 . OFFERING LENGTH TOL: $-0.000/+0.250$. SPEC AMS-QQ-A-200/11 ALSO APPLIES.

1A ACTUAL CHEMISTRY

\$100.000

Kaiser Aluminum

CONFIDENTIAL COMMUNICATION

This correspondence and attachments are intended only for the use of the individual named above and may contain information that is privileged and confidential. If you are not the intended recipient, any dissemination, distribution, or copying is strictly prohibited. If you received this correspondence in error, please immediately notify the sender by telephone at (800) 445-7030. Thank you.

KAISER ALUMINUM QUOTATION

See additional notes at the end of this quote.

Quote Number: 525407

Date: 2/13/2012

Page: 2 of 2

Item	Alloy Temper	Dimensions	Length	Quantity	Unit Price	Leadtime
2	7075 T6511	OD: 2.750" ID: 2.000" Wall: 0.375" Wall: 0.375" Wall: 0.375" Wall: 0.375"	128.0000 In	527 LB	\$23.740/LB	13-14 wks ARO
		Round (HA E3RT) (Tube HA Extruded Seamless)				

Kaiser Part No.: 372415

Weight/ft: 2.9047600

Ship Tolerance: +15%/-15%

Specification: AMS-QQ-A-200/11

Non-Stenciled

Bottom: All 4 sides

External: Cardboard box

Internal: Paper Layer Separation

Item Notes:

THIS IS THE MILL MINIMUM. 66019-128P WITH EXCEPTIONS. WE TAKE EXCEPTION TO OD TOLERANCE AND ARE ONLY OFFERING +/-0.008" MEAN READINGS; OFFERING OVALITY OF: +/-0.015". OFFERING LENGTH TOL: -.000/+0.250". SPEC AMS-QQ-A-200/11 ALSO APPLIES.

2A ACTUAL CHEMISTRY

\$100.000

FOOTER NOTES:

Orders resulting from this quote will be subject to price in effect at the time of shipment. An energy surcharge has been applied to each pound of product produced under orders generated by this quotation and is included in the Price in effect. Additional information with respect to the surcharge is available for your review on the Kaiser Aluminum website at: www.KaiserAluminum.com.

Nathan Facio

E-Mail: nathan.facio@kaiseraluminum.com

Phone: (800) 528-8274 x1020

Fax: (520) 796-0596

Kaiser Aluminum

CONFIDENTIAL COMMUNICATION

This correspondence and attachments are intended only for the use of the addressee named above and may contain information that is privileged and confidential. If you are not the intended recipient, any dissemination, distribution, or copying is strictly prohibited. If you received this correspondence in error, please immediately notify the sender by telephone at (800) 444-7060. Thank you.

0007/013

06/19/2012 TUE 11:44 FAX 613 632 4443 DART HELICOPTER SERVICES



Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
Tel: 613 632 9477
Fax: 613 632 1053

PO REPRINT

Purchase Order ID PO16063

Purchase Order Date 2/01/12

PO Print Date 2/01/12

Page Number 1 of 1

Order From : VID-KA(001)
KAISER ALUMINUM
6573 W WILLYS ROAD
CHANDLER, ARIZONA 85226
USA

Contact Name
Vendor Phone 520 796 1097 Ext.1020
Vendor Fax 520 796 0596
Vendor Account Nbr:

Buyer
Requisition Nbr
Inv. Requisition Nbr 10127-2607
Terms Net 30
Currency USD
FOB Destination-Collect

Ship To : DART AEROSPACE LTD 1270 ABERDEEN
HAWKESBURY, ON K6A 1K7
CANADA

Line Nbr	Reference Revision ID Vendor Part Number	Description/ Org ID	Req Date/ Taxable	Req Qty/ Unit of Measure	Ship Method	Unit Price	Extended Price
1	D0019-128P	Cross-tube Material	3/16/12 Yes	10.00 Each		\$0.0000	\$0.00
		Special Text:	AS PER DWG D0019 REV A R79741 MATERIAL: 7075-T6/T6511 AS PER QQ-A-325/9 OR QQ-A-300/11 SIZE: 2.750" X 0.313" WALL SEAMLESS ALUMINUM TUBE MINIMUM ULTIMATE TENSILE STRENGTH = 77 KSI MINIMUM TENSILE YIELD STRENGTH = 66 KSI				
PO Total:							\$0.00

No substitution or deviation without
consent.
Certificate of Conformity or Material
Certification required when applicable

Change Nbr: 1

Change Date: 2/01/12

Chantal Lavoie

From: Facio, Nathan M. <Nathan.Facio@kaiseral.com>
Sent: February 13, 2012 6:55 PM
To: clavoie@dartaero.com
Cc: Mahan, Steve; llacelle@dartaero.com
Subject: PO 16063; Kaiser Quote 525407
Attachments: D6019-RevA.pdf; po16063 kaiser.pdf; Quote 525407 for Dart 2-13-2012.pdf; TermsAndConditions 1.pdf

Hi Chantal Lavoie,

I have attached a copy of our Quote 525407, in pdf format. Note the price per pound and advise which temper you will want us to mfg, so we can enter this PO in our system.

- 527 lbs (17 pieces) minimum, \$23.74/lb.
- Advise on temper: T6, or T6511.

One more thing, please note on our quote the exceptions we are taking to your print: D6019-128P.

Thank you,

Nathaniel M. Facio - Inside Sales Rep
Kaiser Aluminum - 6573 W. Willis Rd - Chandler AZ 85226.
P: 520-796-3220 Plant Fax: 520-796-0596.

CONFIDENTIAL COMMUNICATION

This email message and any attachments are intended only for the use of the addressee named above contain information that is privileged and confidential. If you are not the intended recipient, any dissemination, distribution, or copying is strictly prohibited. If you received this email message in error, please immediately notify the sender by replying to this email message or by telephone (520) 796-1097 EX 20 and then DELETE the message. Thank You.

DART
aerospaceDart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
Tel: 613 632 0577
Fax: 613 632 1053**PURCHASE ORDER**Purchase Order ID **PO16063**Purchase Order Date 2/01/12
PO Print Date 2/01/12

Page Number 1 of 1

Order From: VII-KAI001

KAISER ALUMINUM
6373 W WILLIS ROADCHANDLER, ARIZONA 85226
USAContact Name
Vendor Phone 520 796 1097 Ext. 1020
Vendor Fax 520 796 0596
Vendor Account NbrBuyer
Requisition Nbr
Tax Resale Nbr 10127-2607
Terms Net 30
Currency USD
FOB Destination-CollecShip To: DART AEROSPACE LTD
1270 ABERDEEN
HAWKESBURY, ON K6A 1K7
CANADAPAID
2/12/12

ce - m20 Btg

Line Nbr	Reference Revision ID Vendor Part Number	Description/ Mfg ID	Req Date/ Taxable	Unit of Measure	Req Qty/ Unit of Measure	Ship Method	Unit Price	Extended Price
1	D6019-128P	CrossTube Material	3/16/12 Yes		10.00 Each		\$0.0000	\$0.00

T84

Special Inst: AS PER DWG D6019 REV. A
D79741
MATERIAL: 7075-T6/T6511 AS PER QQ-
A-225/9 OR QQ-A-200/11
SIZE: 2.750" X 0.313" WALL SEAMLESS
ALUMINUM TUBE
MINIMUM ULTIMATE TENSILE
STRENGTH = 77 KSI
MINIMUM TENSILE YIELD STRENGTH
= 66 KSI

PO Total: \$0.00

MATERIAL CERTIFICATION
REQ'D UPON DELIVERY

Change Nbr: 1

Change Date: 2/01/12

No substitution or deviation without
consent.
Certificate of Conformity or Material
Certification required when applicable

010/013

06/19/2012 TUE 11:45 FAX 613 632 4443 DART HELICOPTER SERVICES

Linda Lacelle

From: Bill Beckett <bbeckett@darths.com>
Sent: January-30-12 9:53 AM
To: Linda Lacelle
Subject: RE: crosstube mat'l to order from Kaiser

Linda,
Just between flights, gotta run. If you think this is an appropriate trial one, go with it.
Bill

From: Linda Lacelle [mailto:llacelle@dartaero.com]
Sent: January 30, 2012 9:13 AM
To: Bill Beckett
Subject: RE: crosstube mat'l to order from Kaiser

So, should we go with the D6019-128??
LL

From: Linda Lacelle [mailto:llacelle@dartaero.com]
Sent: January-25-12 1:57 PM
To: Bill Beckett (bbeckett@dartaero.com)
Subject: crosstube mat'l to order from Kaiser

Suggest one of the following:
D6019-128
D6002-115
D6004-115

Have an email out to Alunna, but we'd better do something on these now..

LL

Thank You,
Linda Lacelle
Production Manager
Dart Aerospace Ltd
Hawkesbury, ON
Phone: 613 632 9577
Fax: 613 632 1053
Cell: 613 676 1855

326-796-1097

79741
792

Disclaimer - This email and any files transmitted with it are confidential and may contain privileged or copyright information. You must not present this message to another party without gaining permission from the sender. If you are not the intended recipient you must not copy, distribute or use this email or the information contained in it for any purpose other than to notify us. If you have received this message in error, please notify the sender immediately, and delete this email from your system. We do not guarantee that this material is free from viruses or any other defects although due care has been taken to minimize the risk. Any views expressed in this message are those of the individual sender, except where the sender specifically states them to be the views of DART Helicopter Services.

DART
Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
Tel: 613 632 9377
Fax: 613 632 1033

PO REPRINT

Purchase Order ID: PO16063

Purchase Order Date: 2/1/12
PO Print Date: 2/14/12

Page Number 1 of 1

Order From: KAISER ALUMINUM
6573 W WILLIS ROAD
CHANDLER, ARIZONA 85226
USA

VU-KA1001

1107358

Contact Name
Vendor Phone: 520 796 1097 Ext. 1020
Vendor Fax: 520 796 0586
Vendor Account Nbr

Buyer
Requisition Nbr
Quote Nbr: 10127-2607
Terms: **Cash Before Shipment**
Currency: USD
FOB: Destination-Collect

Ship To: DART AEROSPACE LTD
1270 ABERDEEN
HAWKESBURY, ON K6A 1K7
CANADA

DWG D6019 Rev. A With Exceptions

Line Nbr	Reference Revision ID Vendor Part Number	Description/ Mfr ID	Run Date/ Tagable Hot Rush 5/24/12	Req. Qty/ Unit of Measure	Ship Method	Unit Price	Extended Price
1	D6019-1280	Extruded Material	Y02	17.00	Sea	\$705,8400	\$12,510.98

With Exceptions

See Quote 525407

* No Stencil
* No Oil

Kaiser Aluminum
Resolved Order
Will Ship 5/14/12
Will Arrive 5/24/12
Thank You,
Nathan Fazio

HOT RUSH

Special Inst: AS PER DWG D6019 REV. A
079741
MATERIAL: T3511 AS PER AMS-200/11
2660 OR QQ-A-200/11
SIZE: 2.75" X 0.313" WALL
SEAMLESS ALUMINUM TUBE
MINIMUM ULTIMATE TENSILE
STRENGTH = 77 KSI
MINIMUM TENSILE YIELD
STRENGTH = 66 KSI

NOTE: PLEASE PRODUCE IN T3511

OD Tol: +/- .008" max.
Wall Tol: +/- .015" max.
Ovality: +/- .015"
Length Tol: 7000" / +/- .250"

AMS-200/11
Also conforms to QQ-A-200/11

PO Total: \$12,510.98

PO Instructions: question no. 525407

No substitution or deviation without
consent.
Certificate of Conformity or Material
Certification required when applicable

Change Nbr: 2

Change Date: 2/14/12

012/013

06/19/2012 TUE 11:45 FAX 613 632 4443 DART HELICOPTER SERVICES

Eric Downing

From: Patrick Smith <psmith@dartaero.com>
Sent: Wednesday, June 20, 2012 7:16 AM
To: 'David Shepherd'; 'Eric Downing'
Cc: cprovencal@dartaero.com; 'Bill Beckett'; 'Linda Lacelle'; 'Isam El-Kassis'
Subject: RE: B79741.xlsx

Eric,
Package up the Tube which is being returned to Kaiser and have the Tubes which David has permitted to be used for production identified and stored by the production group.
Thanks,
Pat

From: David Shepherd [mailto:dshepherd@dartaero.com]
Sent: June-19-12 6:53 AM
To: 'Patrick Smith'; 'Eric Downing'
Cc: cprovencal@dartaero.com; 'Bill Beckett'; 'Linda Lacelle'
Subject: RE: B79741.xlsx

Pat/Eric,

Re-arranged the data a bit into the table below with my recommended dispositions. Basically recommend keeping anything with minimum OD above (or close to) 2.738 since dwg D6019 requires OD to be 2.75 +/- 0.012 including ovality. Therefore ... recommend keeping 7 tubes and returning the other 10 to Kaiser.

David

Tube	A 0	A 180	B 0	B180	MID 0	MID 180	Disposition
1	2.738	2.750	2.737	2.740	2.738	2.749	Keep
2	2.745	2.753	2.738	2.749	2.742	2.751	Keep
3	2.738	2.753	2.741	2.751	2.745	2.753	Keep
4	2.717	2.771	2.740	2.750	2.742	2.750	Return
5	2.739	2.748	2.738	2.754	2.740	2.747	Keep
6	2.738	2.750	2.738	2.754	2.741	2.750	Keep
7	2.736	2.751	2.735	2.765	2.732	2.758	Return
8	2.738	2.750	2.735	2.756	2.734	2.756	Return
9	2.736	2.751	2.734	2.754	2.741	2.749	Return
10	2.739	2.753	2.739	2.745	2.737	2.753	Keep
11	2.719	2.773	2.737	2.747	2.739	2.749	Return
12	2.734	2.751	2.738	2.751	2.738	2.760	Return
13	2.736	2.740	2.738	2.743	2.734	2.744	Return
14	2.742	2.743	2.738	2.748	2.738	2.745	Keep
15	2.731	2.755	2.736	2.747	2.731	2.758	Return
16	2.739	2.756	2.735	2.751	2.742	2.762	Return
17	2.741	2.748	2.733	2.756	2.743	2.745	Return

From: Patrick Smith [<mailto:psmith@dartaero.com>]

Sent: June-14-12 8:42 AM

To: cprovencal@dartaero.com; Eric Downing

Cc: dshepherd@dartaero.com

Subject: B79741.xlsx

Hi Chris,

Attached is the Kaiser Material D6019-128 outside diameter dimensions re-measured this morning.

Pat